Dart Aerospace Ltd. Tuesday, 12/5/2006 8:20:57 AM Date: Kim Johnston User: **Process Sheet** : GUIDE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 29830 **Estimate Number** : 11073 : D31373 : N/A Part Number P.O. Number OK POB. TLOS : D3137 REV D 三 S.O. No. : 1/1/ **Drawing Number** : 12/5/2006 This Issue Project Number : N/A : NC Prsht Rev. : NA : MACHINED PARTS **Drawing Revision** First Issue Type : 28149 Material **Previous Run** Each : 12/23/2006 Qty: 30 Um: **Due Date** Written By Checked & Approved By New Issue NG Comment : Est Rev:A 02.05.29 **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: MDELRINB075X1250 Delrin Bar 1.0 Comment: Qty.: 0.0831 f(s)/Unit Total: 2.4917 f(s) Matl:Black Delrin bar 1.250" x .750" ( ref DART spec, M-DELRIN-B ) 06/12/10 Batch: BAND SAW 2.0 Comment: BAND SAW Cut Blanks.Blank size: 1.250" x .750" x .950" long HAAS CNC VERTICAL MACHINING #1 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA242 & Dwg D3137 2-Deburr INSPECT PARTS AS THEY COME OFF MACHINE QC2 4.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

Comment: SECOND CHECK

QC8

Tut 06/12/11

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### **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					<u>.</u>			
Part No	:	PAR #: Fault Category:	_ NCR	: Yes	No DQ	A: 77	∑ Date:⊜	6/12/12
				ΟΛ.	N/C Close	4.	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B	Section B		Annessal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:20:57 AM Kim Johnston User: **Process Sheet** Drawing Name: GUIDE Customer: CU-DAR001 Dart Helicopters Services Job Number: 29830 Part Number: D31373 Job Number: Description: Seq. #: **Machine Or Operation:** PACKAGING RESOURCE #1 PACKAGING 1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ FINAL INSPECTION/W/O RELEASE 7.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

# Dart Aerospace Ltd

W/O:		WORK ORDER CH	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	
			QA: I	N/C Close	d:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29830
Description: Guide	Part Number:	D3137-3
Inspection Dwg: D3137 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Protot	ype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.175	+/-0.010	· 175					
Ø0.257	+0.005/-0.000	.259					
Ø0.65 x 100°	+/-0.030	.647x100°					
0.425	+/-0.010	425	,/_			·	
0.550	+/-0.010	.55					
1.100	+/-0.010	1.101					
0.470	+/-0.010	,470					
0.850	+/-0.010	. 852	/_				
0.143	+/-0.010	. 143					
					•		
	·-						
				-			

Measured by:	Audited by:	anh	Prototype Approval:	N/A
Date: 00/12/10	Date:	16/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	04.11.12	0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100°	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM O	



DESIG	n DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED	DRAWING NO. REV. E
	#	#	D3137 SHEET 1 OF 5
DATE			TITLE SCALE
05.	11.23		BRACKET ASSEMBLY 1:1
Α		02.04.17	NEW ISSUE
В		03.01.16	ADD RIDGES; ADD MAT'L PROP.
С		03.08.15	ADD -043
D		04.11.03	RE-DESIGN D3137-5; CHANGE DIMS
Ε		05.11.23	ADD -045

RELEASED 05.12.09

> MS24694-S101 SCREW D3137-5 WASHER D3137-3 GUIDE INSTALL ON SAME SIDE AS C'SINKS (OPPOSITE SIDE FROM RIDGES)

D3137-1 BRACKET (-041 SHOWN) OR D3137-7 BRACKET (-043 SIMILAR) OR D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN) D3137-043 BRACKET ASSEMBLY (SIMILAR)

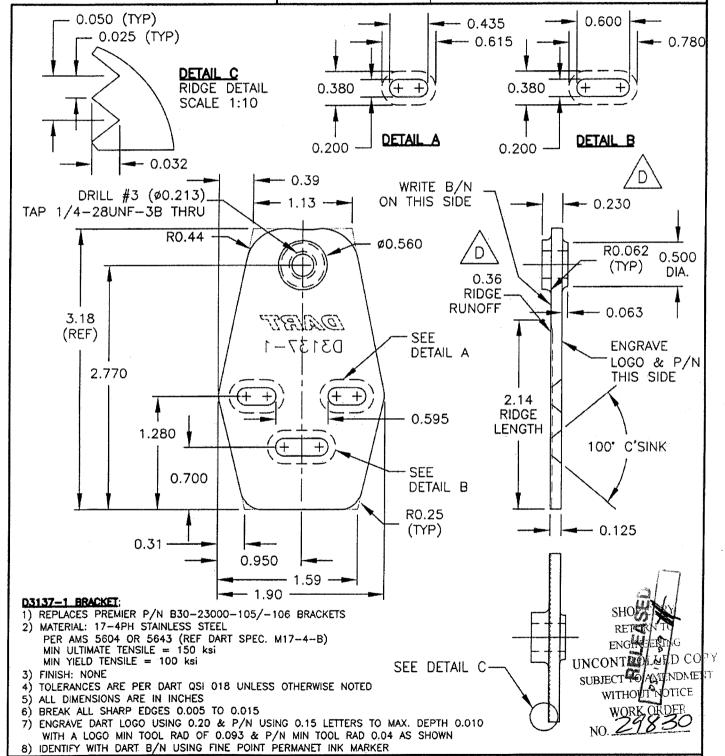
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CHECKED #	APPROVED	DRAWING NO.	REV. E SHEET 2 OF 5
DATE		TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	1:1

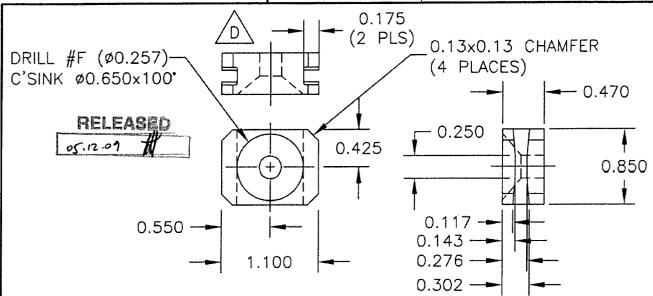


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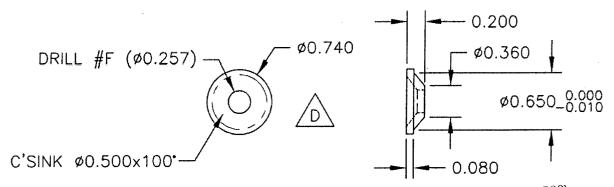


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一個一	-	D3137		SHEET 3 OF	5
DATE		TITLE		SCA	ILE.
05.11.23		BRACKET	ASSEMBLY		1:1



### D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



#### D3137-5 WASHER

1) REPLACES PREMIER P/N B30-23000-209

2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPECOM 601 TORN) COPY

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL EDGES 0.005 TO 0.015

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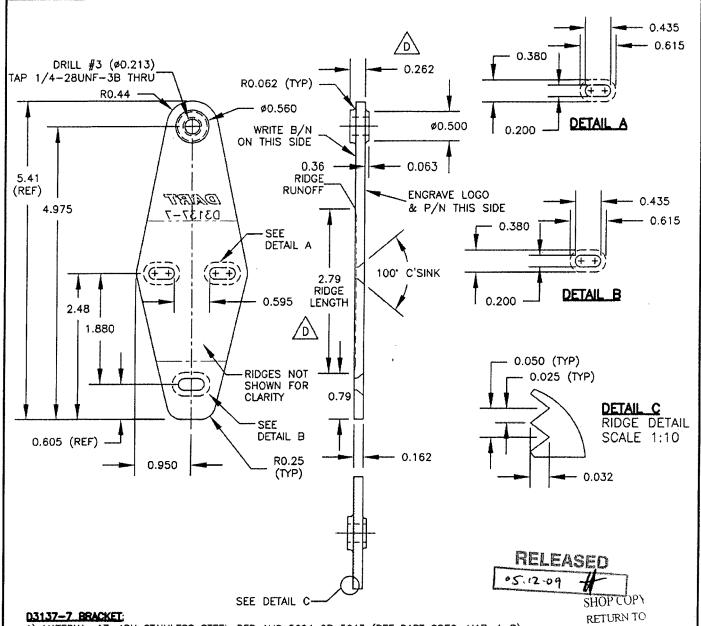
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CHECKED	APPROVED #	DRAWING NO. D3137	REV. E SHEET 4 OF 5
DATE		TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	2:3



1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN

7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

**ENGINEERING** 

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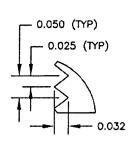
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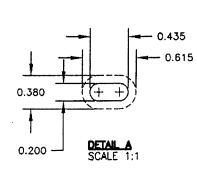
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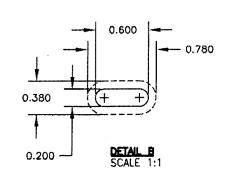


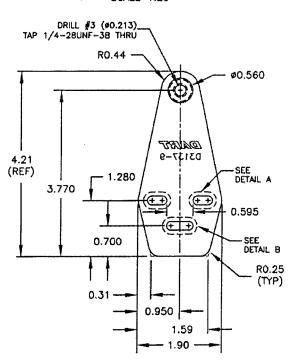
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CHECKED	APPROVED	DRAWING NO.	REV. E SHEET 5 OF 5
DATE	<del></del>	TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	1:2



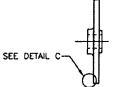
DETAIL C RIDGE DETAIL SCALE 1:20







0.262 0.500 R0.062 DIA. (TYP) WRITE B/N ON THIS SIDE 0.063 0.36 **ENGRAVE** RIDGE LOGO & P/N THIS SIDE RUNOFF 2.14 RIDGE LENGTH 100° C'SINK 0.162



03137-9 BRACKET

1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi

3) FINISH: NONE

3) FINISH: NUNE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.015
7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

ENGINEERING

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WORK ORDER

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